

Work Order ID 48564

June 26, 2009 7:26:15 AM



Page 1

Item ID: D407-547-047 **BK**

Accept



Setup Start



Revision ID: F

Item Name: Console High Slope

Stop



Start Date: 15/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: **MF**

Date: **09-09-24**

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-547

Rev F

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

I-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg
D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4 2-Debur

EP 09/07/14 (6)

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> 80910714

(LC)

(LC)-2

φ
φ

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Grind weld relief chamfer as per Dwg D206-547 2-Rivet extrusion to sides as
per Dwg D206-547 using Rivet MS20470AD3-4

EP 09/09/01 (6)

Picklist Print

June 26, 2009 7:26:14 AM

Work Order ID: 48564

Parent Item: D407-547-047RevF

Parent Item Name: Console High Slope

Comments:



Start Date: 15/07/2009

Start Qty: 6.00

Required Date: 03/08/2009

Required Qty: 6.00

Page 1

Work Order ID 48564

June 26, 2009 7:26:15 AM

Item ID: D407-547-047

Revision ID: F

Item Name: Console High Slope

Start Date: 15/07/2009 Start Qty: 6.00

Required Date: 03/08/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp



Accept



Setup Start

Stop

Cust Item ID:

Customer:



Page 3

Work Order ID 48564

June 26, 2009 7:26:15 AM

Item ID: D407-547-047

Revision ID: F

Item Name: Console High Slope

Start Date: 15/07/2009 Start Qty: 6.00

Required Date: 03/08/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 80102102

X6LH
X6RH

6

140



Large Fab

Large Fab

Large Fab

Memo

1-Weld as per Dwg D206-5471 A/R
Batch: H111385

AL ROD

2-Grind weld as per dwg D206-547

0.00

0.00

SP 09. 09. 21.

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00


0.00

X6LH
X6RH

BE 09/09/25

Date: Friday, 12/06/2009 9:59:09 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE ASSEMBLY 407
Job Number : 48564	
Estimate Number : 11720	
P.O. Number :	Part Number : D407547047
This Issue : 12/06/2009 S.O. No. :	Drawing Number : D206-547 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 47214	Material :
Written By :	Due Date : 19/06/2009 Qty: 6 Um: Each
Checked & Approved By : 	
Comment : Est Rev:l 06-01-05 Removed Packing Kit JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2024	Console Extrusion
-----	-------	-------------------



Comment: Qty.: 3.5910 Each(s)/Unit Total : 21.5460 Each(s)

D2024 Extrusion

Batch MOI

2.0	✓ SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	---------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

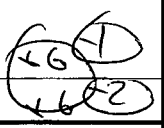
1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

3.0	✓ QC6	DIMENSIONAL CHECK
-----	-------	-------------------



Comment: DIMENSIONAL CHECK

Sort 12/14 

4.0	✓ D26041	Console Side LH, 407 Console
-----	----------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2604-1 Side LH

5.0	✓ D26042	Console Side RH, 407 Console
-----	----------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:59:09 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 48564

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2604-2 Side RH

6.0

✓

D2606

Console Bracket, 206/407 Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2606 Bracket

7.0

✓

D2608

Bracket, 407 Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2608 Bracket

8.0

✓

MS20470AD33

Rivet,Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 MS20470AD3-3 Rivet

9.0

✓

MS20470AD34

Rivet,Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 MS20470AD3-4 Rivet

10.0

✓

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:59:09 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 48564

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

✓ LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D206-547

A/R AL ROD Batch: _____

2-Grind weld as per dwg D206-547

13.0

✓ QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

14.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

15.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

✓ POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

17.0

✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:59:09 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 48564

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

19.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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WITHOUT NOTICE
WORK ORDER
NO. 18564

97.03.05 KLE

SECTION A-A: WELD RELIEF DETAIL
NTS

D2607 BRACKET (1)

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 2 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY		SCALE 1:4

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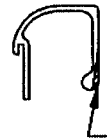
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N1) _____

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DART

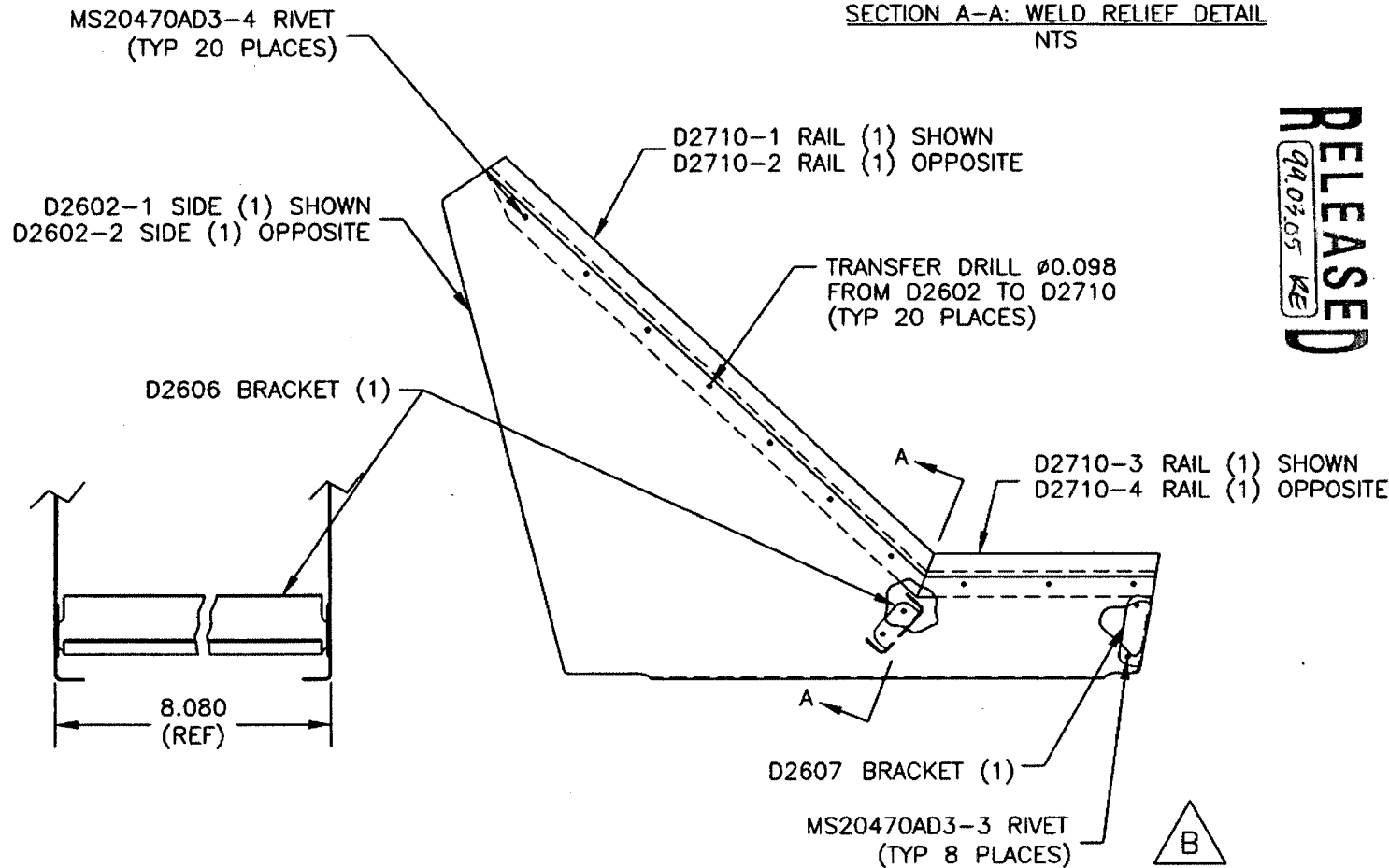
RELEASED
94.03.05 KE

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CHECKED	CP	APPROVED	KE	
DATE	99.02.11	TITLE	D206-547	REV. F
			CONSOLE ASSEMBLY	SHEET 3 OF 5
				SCALE 1:4



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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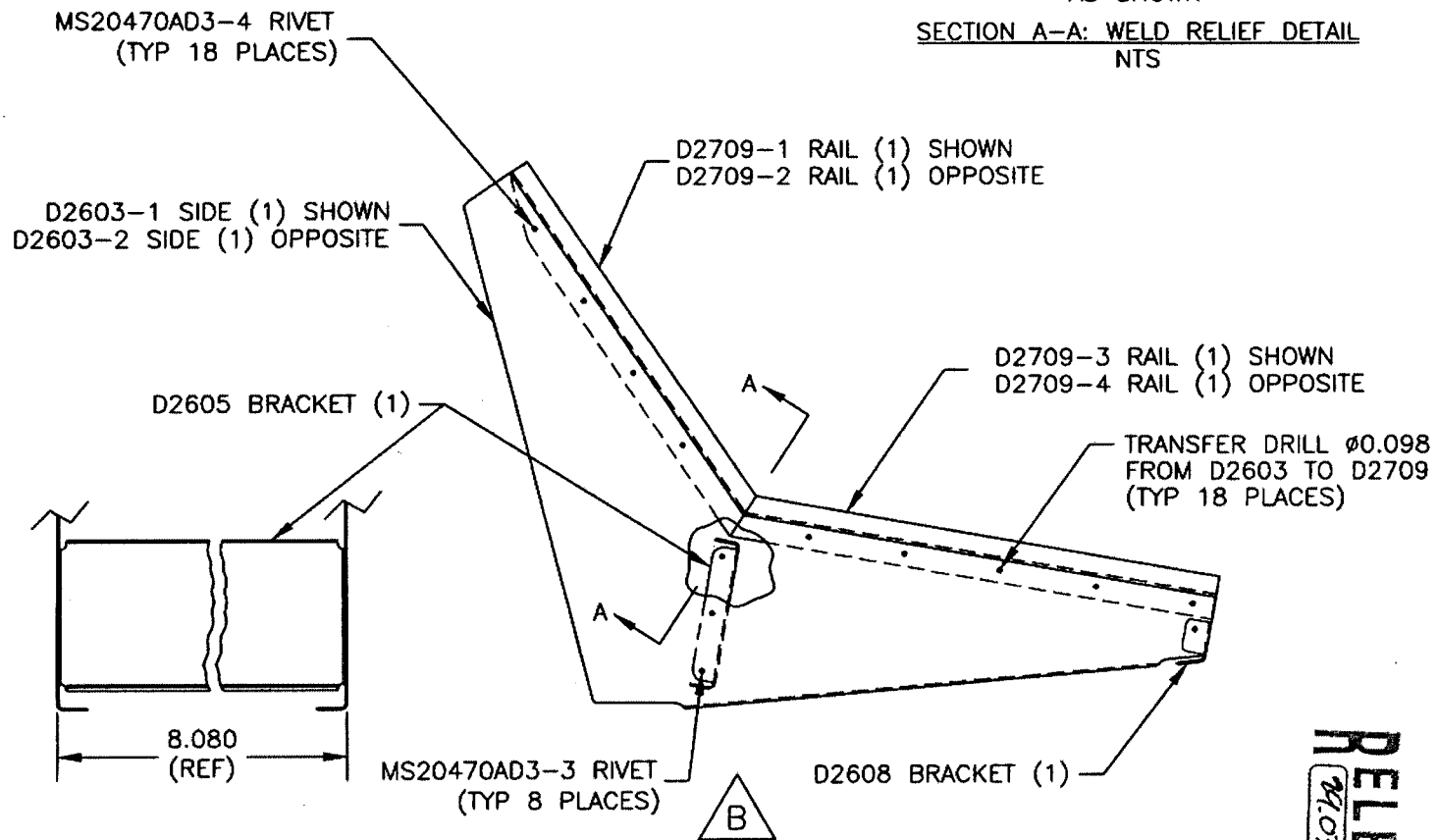
WORK ORDER
NO. 48564

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
140305 RE

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
CHECKED JP	APPROVED RE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 4 OF 5
	SCALE 1:4	

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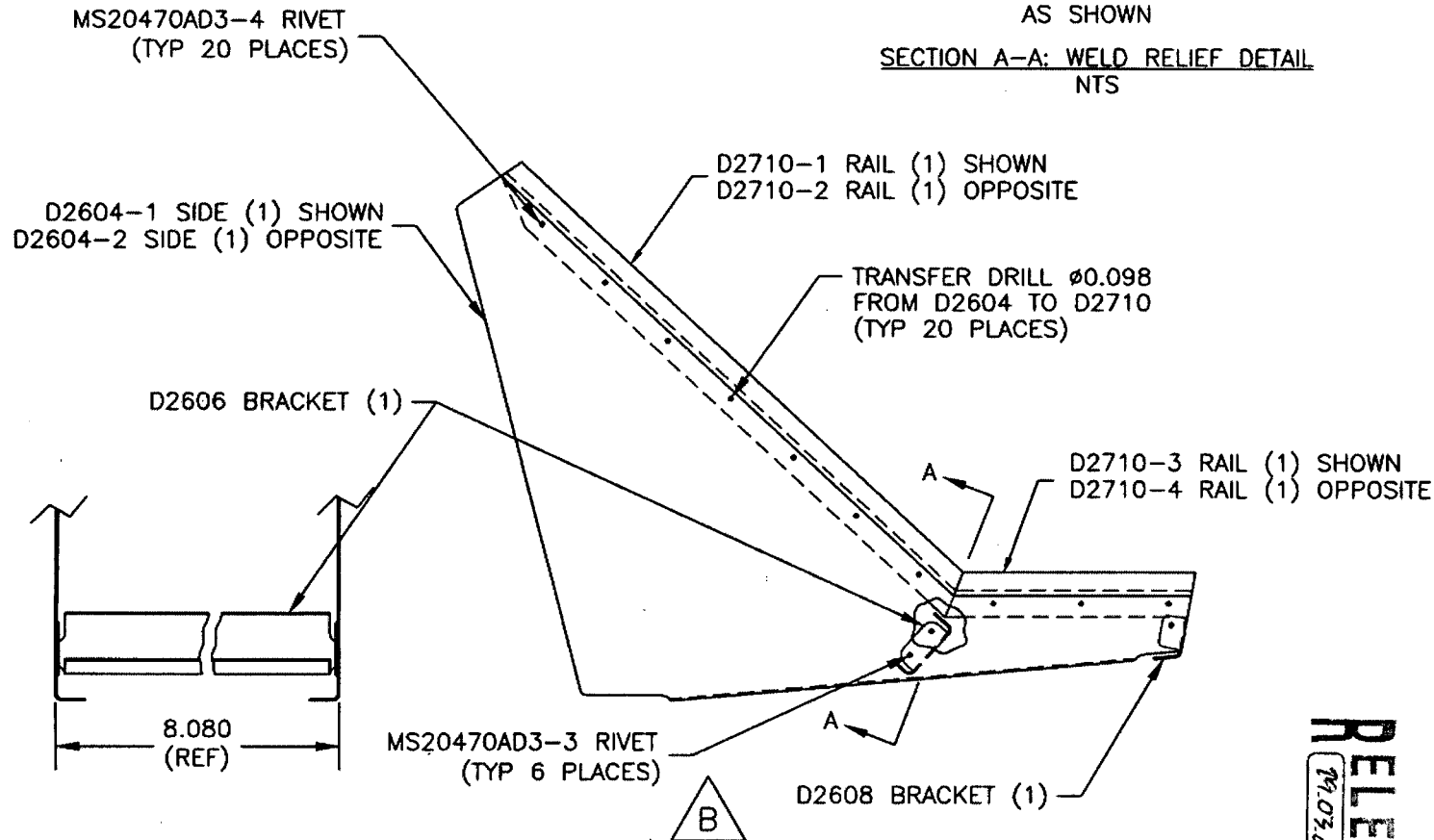
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NO. 48561

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
19.03.05 KE

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	UP	APPROVED	KE	
DATE	99.02.11	DRAWING NO.	D206-547	REV. F
TITLE	CONSOLE ASSEMBLY	SHEET 5 OF 5	SCALE	1:4



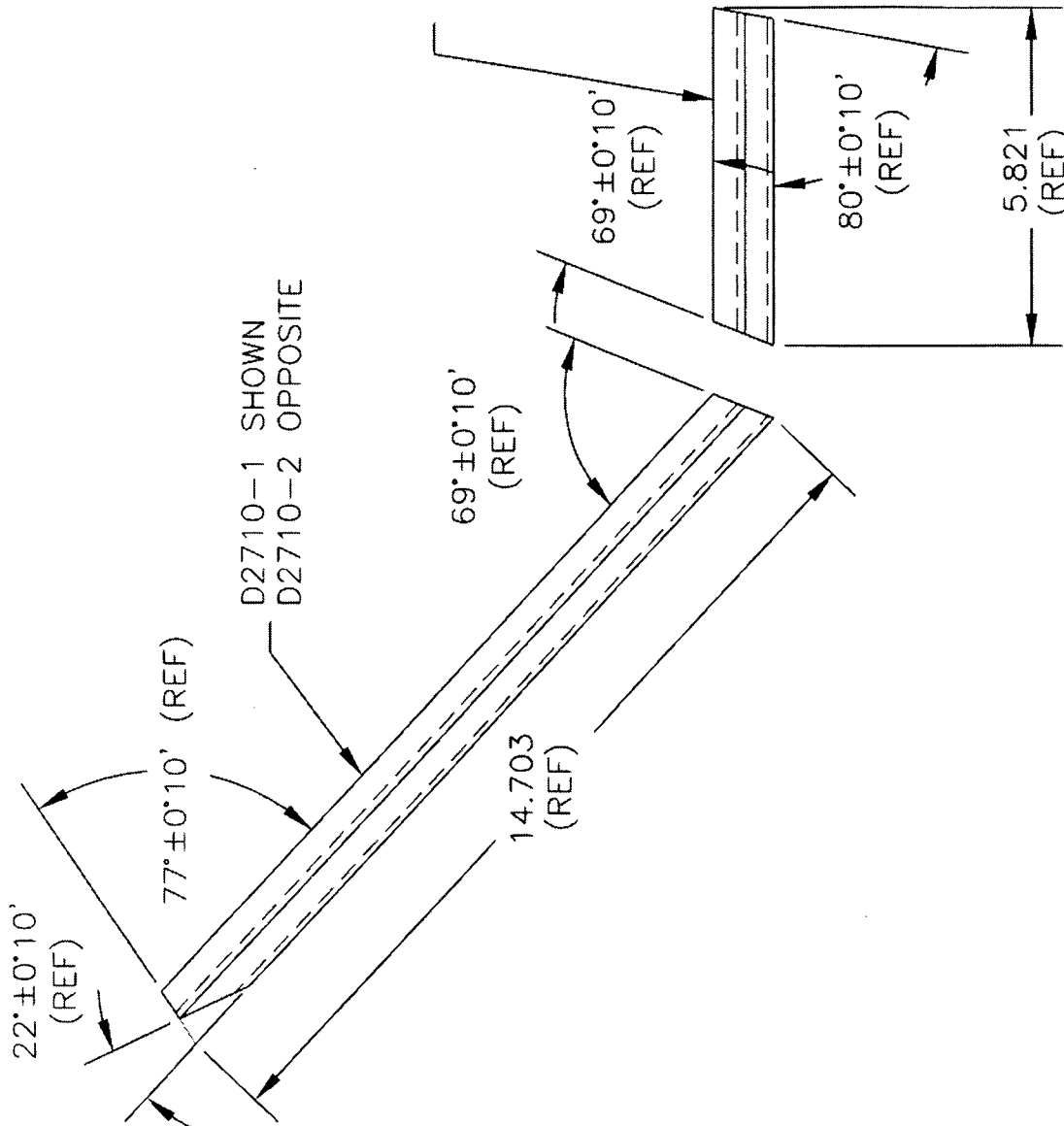
DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED KE	DRAWING NO. D2710	REV. B SHEET 1 OF 1
DATE 99.02.11		TITLE CONSOLE SIDE RAIL	SCALE 1:3
A	97.10.25	NEW ISSUE	
B	99.02.11	DELETE WELD, ADD TEMPL. (TSR A1020)	

REFERENCE ONLY

D2710-3 SHOWN
D2710-4 OPPOSITE



RELEASED
99.03.05 KE



MATERIAL: MAKE FROM D2024 EXTRUSION
MAKE PER TEMPLATE # DT8264
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED